

*stop findy*

# Work Order ID 56088

February 10, 2010 11:22:21 AM



Item ID: D212-725-1-209

Accept



Setup Start



Revision ID:

Stop



Item Name: Right Front Panel

Start Date: 2/10/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/17/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: *10-2-10* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D212-725-1	PG1

100 0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D212-725-1-205

Dwg Rev: *PRG PC71*

Prog Rev: *Lim*

2-Deburr if necessary

*VB 10-2-11*

①

110 0.00



QC

Memo

0.00

Quality Control

*VB 10-2-11*

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56088**

February 10, 2010 11:22:21 AM

Page 2

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Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

S 10/02/11

(X)

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

JL 10/02/11

(X)

Ø

HandFinish

Memo

0.00

Hand Finishing

140

Spray Painting per QSI005 4.2

0.00

m

10-02-16

(X)

SprayPaint

Memo

0.00

Spray Painting

PAINT FLAT BLACK AS PER DWG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56088

February 10, 2010 11:22:21 AM



Page 3

Item ID: D212-725-1-209

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Start Date: 2/10/10 Start Qty: 1.00



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Required Date: 2/17/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

0.00



~~QC~~ Inspect Part Finish

8.10/02/16

70

QC

Memo

0.00

Quality Control

160

0.00



Identify as per dwg & Stock Location: \_\_\_\_\_

SENT TO HARVEY  
AT EAGLE UNDER  
POS. RECALL  
10/02/16

10-2-16

Packaging

Memo

0.00

Packaging

170

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 10.02.10 AUTH W

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

MF  
10-2-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

February 10, 2010 11:22:26 AM

Work Order ID: 56088



Parent Item: D212-725-1-209



Parent Item Name: Right Front Panel

Start Date: 2/10/10

Required Date: 2/17/10

Comments: IPP RevA: new issue DD 10.02.10 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	226.2623	2.4411			
											1810-2-11	
6061-T6 .125 Sheet												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	226.2623	
110062	1.85	
111642	19.592	
112476	32	
112567	18.7403	
113424	58.08	
113608	96	

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
113424  
\_\_\_\_\_

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 56088
<b>Description:</b> RIGHT FRONT PANEL		<b>Part Number:</b> D212-725-1-209
<b>Inspection Dwg:</b>	<b>Rev:</b> PRELIMINARY	<b>Page 1 of 1</b>

D212-725-1-209

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.34	± .030	6.395	*			
8.33	± .030	8.334	*			
4.15	± .030	4.153	*			
4.85	± .030	4.860	*			
5.15	± .030	5.153	*			
5.85	± .030	5.850	*			
6.15	± .030	6.153	*			
6.85	± .030	6.853	*			
7.40	± .030	7.404	*			
8.10	± .030	8.103	*			
8.65	± .030	8.656	*			
9.35	± .030	9.358	*			
9.90	± .030	9.904	*			
10.60	± .030	10.606	*			
14.87	± .030	14.870	*			
16.70	± .030	16.70	*			
16.97	± .030	16.97	*			
17.25	± .010	17.22	*			

<b>Measured by:</b> KB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-2-11	<b>Date:</b> 10/2/11	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 56088
<b>Description:</b> RIGHT FRONT PANEL		<b>Part Number:</b> D212-725-1-23
<b>Inspection Dwg:</b> D212-725-1-209	<b>Rev:</b> PRELIMINARY	<b>Page 1 of 1</b>

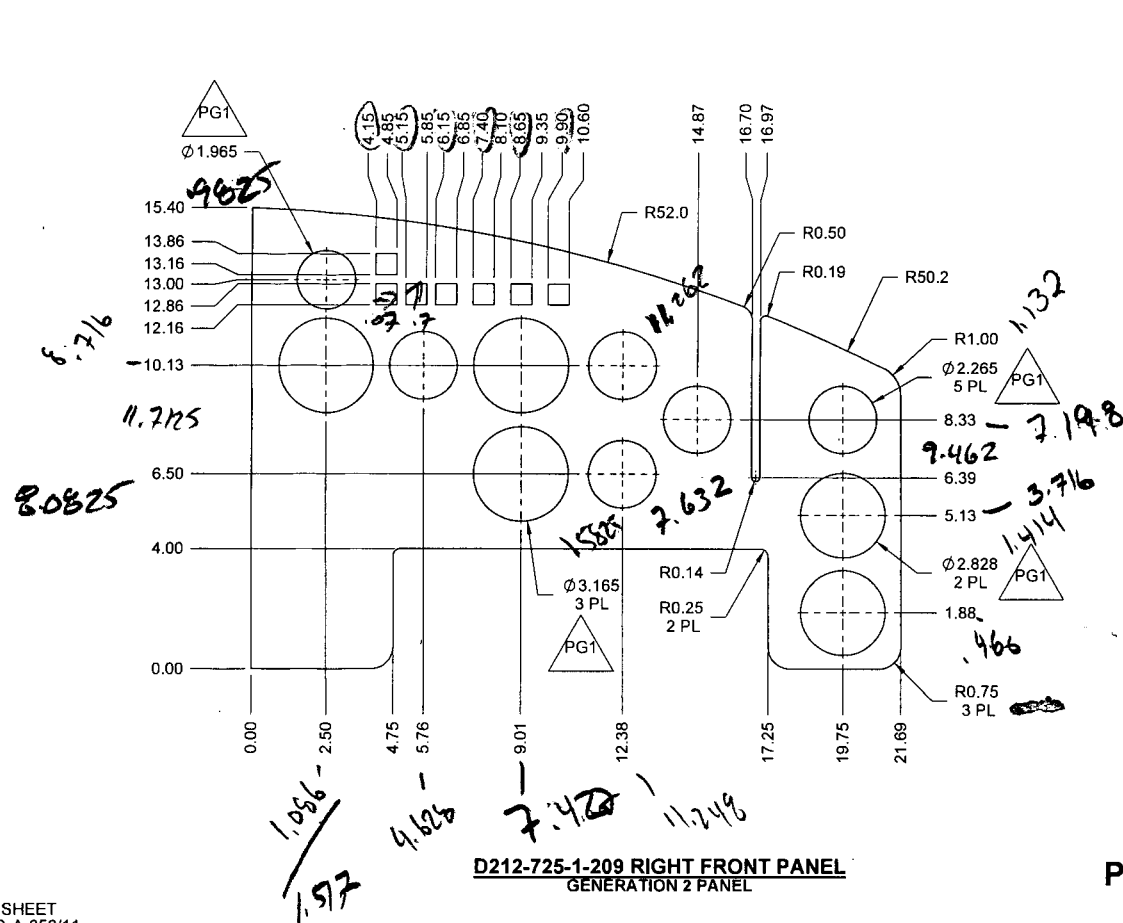
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.965	+ .012 - .001	1.966	✓			
2.265	+ .012 - .001	2.266	✓			
2.828	+ .012 - .001	2.827	✓			
3.165	+ .012 - .001	3.166	✓			
4.00	± .03	3.999	✓			
6.50	± .030	6.505	✓			
10.13	± .030	10.13	✓			
12.16	± .030	12.16	✓			
12.86	± .030	12.875	✓			
13.00	± .030	13.00	✓			
13.16	± .030	13.16	✓			
13.86	± .030	13.86	✓			
15.40	± .030	15.40	✓			
2.50	± .030	2.503	✓			
4.75	± .030	4.759	✓			
5.76	± .030	5.762	✓			
9.01	± .030	9.009	✓			
12.38	± .030	12.375	✓			
17.25	± .030	17.250	✓			
19.75	± .030	19.750	✓			
21.69	± .030	21.690	✓			
1.88	± .030	1.884	✓			
5.13	± .030	5.131	✓			

<b>Measured by:</b> PB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-2-11	<b>Date:</b> 10/02/11	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SHOP COPY  
RETURN TO:  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 56088  
25-0-2-10

**PRELIMINARY ISSUE**

10.01.27

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET  
QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.125  
OR 2024-T3 ALUMINUM SHEET  
QQ-A-250-1/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC. M2024T3S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PAINT FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39.50  
PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.15 lbs

**D212-725-1-209 RIGHT FRONT PANEL**  
GENERATION 2 PANEL

PG1	REFORMAT DRAWING TO CURRENT STANDARDS: Ø2.828 WAS Ø2.812 (ZN C3-1); Ø2.265 WAS Ø2.250 (ZN C3-1); Ø1.965 WAS Ø1.950 (D6-1); Ø3.165 WAS Ø3.150 (ZN B4-1)	RF	10.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.27		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D212-725-1-209</b> TITLE <b>212S DETAIL PARTS</b> REV. PG1 SHEET 1 OF 1 SCALE NTS			
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